

Work Order ID 72806

Monday, August 15, 2011 10:43:45 AM



Page 1

Item ID: D3720-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 8/15/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/18/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/08/15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3720

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3720 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

6061.128

B11-8-15



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-15

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/15/15








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Item ID: D3720-2 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step Spacer
Start Date: 8/15/2011 Start Qty: 8.00  Cust Item ID:
Required Date: 8/18/2011 Req'd Qty: 8.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	C'sink as per dwg D3720								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten notes:
- Above 130: 5/14/08/16 (17)
- Above 140: 5 w/08/16
- Above 150: 17 d 11/08/16

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Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 8/15/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/18/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

17x Ø M-11/08/16

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

EP 11/08/16 (17)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18

11-08-16 (17)

Picklist Print

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Page 1

Work Order ID: 72806



Parent Item: D3720-2



Parent Item Name: Step Spacer

Start Date: 8/15/2011

Required Date: 8/18/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

110

sf

135.6514

0.085

0.715789

1.5



B11-8-15

6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT021

135.6513684

113608

77.17

116700

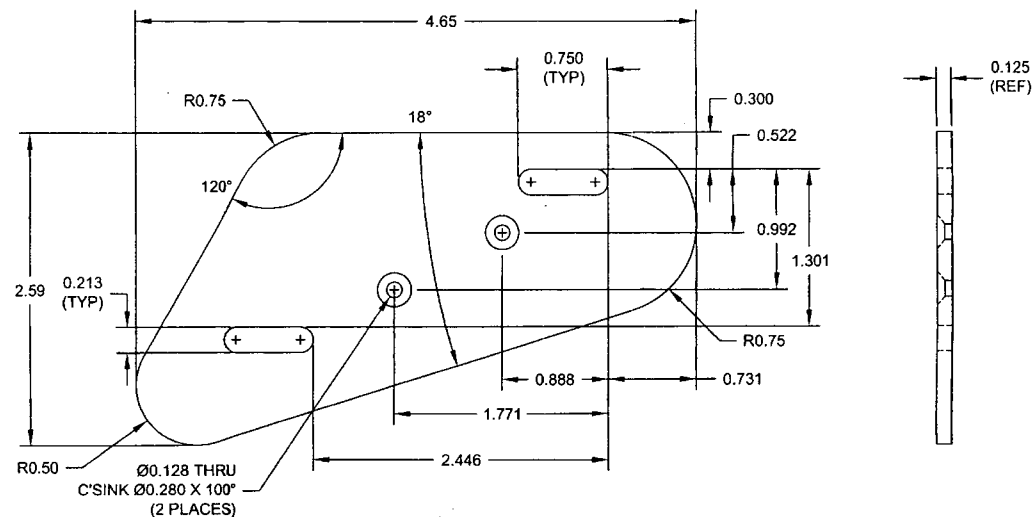
3.98136842

118217

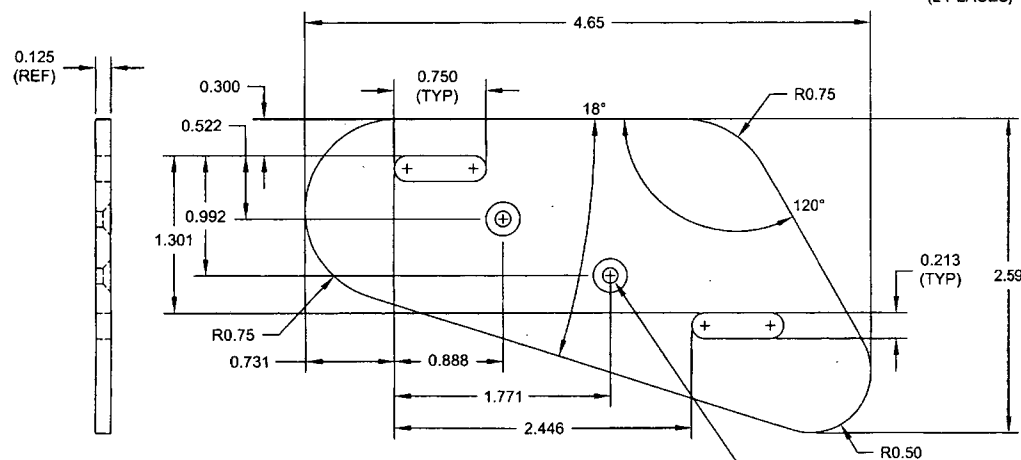
54.5

116700

(17)



D3720-1 STEP SPACER



D3720-2 STEP SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

CL 11/08/15
W10.72806

RELEASED
07-01-10

A NEW ISSUE		PH	07.12.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BE		
CHECKED	LG	DRAWING NO.	REV. A
MFG. APPR.	W	D3720	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.	W	STEP SPACER	1:1
DATE	07.12.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART AEROSPACE LTD		Work Order:	72806
Description: Step Spacer		Part Number:	D3720-2
Inspection Dwg: D3720 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.130	✓		V 1802	
4.65	+/-0.030	4.646	✓		✓	
2.59	+/-0.030	2.577	✓		✓	
0.750	+/-0.010	.749	✓		✓	
0.300	+/-0.010	.303	✓		✓	
0.522	+/-0.010	.524	✓		✓	
0.992	+/-0.010	.989	✓		✓	
1.301	+/-0.010	1.323	✓		✓	
0.731	+/-0.010	.725	✓		✓	
0.888	+/-0.010	.899	✓		✓	
1.771	+/-0.010	1.767	✓		✓	
2.446	+/-0.010	2.450	✓		✓	
0.213	+/-0.010	.213	✓		✓	

Measured by: RB Date: 11-8-17	Audited by: [Signature] Date: 11/8/17	Prototype Approval: N/A Date: N/A	
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Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD [Signature]	[Signature]